

-6/2

Date: Friday, 1/25/2008 10:48:25 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B  
 Job Number : 36962A  
 Estimate Number : 10803  
 P.O. Number :  
 This Issue : 1/25/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D206642641  
 First Issue : / / Type : LANDING GEAR Drawing Number : D3288 REV F W/R  
 Previous Run : 36961A Drawing Revision : F  
 Material :  
 Due Date : 3/10/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 18080125  
 Comment : Est Rev:B 05.11.15 Added washers for aft cap, wearshoes and ring EC  
 Est Rev:C 06-05-31 Revised steps JLM  
 Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM  
 Est Rev:E 07-12-06 ECN 1080p DD verified by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG003

N/A

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 3" OD Bent Tube 032449

JD 8-4-1

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap 033475 86 080402

4.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler 033295 8-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube,grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288,Grind to obtain proper fit

A/R AL ROD

Batch: M106330 / M106762

8E 0804-02

4-Grind welds flush to cap on top surface onlly.

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9-Insert D3286-1 doubler using DT8732 & DT8879 ,then locating doubler off the  
D3286-1 doubler ,leave Dt8732 for added support

3/16" holes cleco

10-Drill D3286-1 doubler rivet holes in tube using #40 drill,spot drilling doubler at the same time.

11-Working from center out,drill #30 holes into D3286-1 Doubler.cleco each hole after its drilled,Verify  
angle of holes to accomodate rivet heads.

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

13-Remove D3286-1 doubler,identify orientation,deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

7421

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/21 (40)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

U 8-4-22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/04/23

9.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet M107478

(32)

M107478

(21)

U 8-4-22

10.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3289-041 Float Web

B37344

(1)

U

8-4-22

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Holes to finished size as per DWg D3288.Deburr.

2-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

3-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

Sikaflex expire date:

Start: 8-4-22

Finish: 8/4/23

(Adhere for 12 hours)

M107809

8-10-1

Time: 2:30 pm

Time: 8:45 AM

U 8-4-22

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/23 (40)

W/O:		WORK ORDER CHANGES					
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Description :

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

*DD SL 8-4-30*

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Debur

*SL 8-5-1*

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer

*B37859*

*BE 08/05/07*

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D3275-1 Crossbolt spacer

*B37859*

*B35210*

*BE 08/05/07*

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer

*B37723*

*BE 08/07/07*

W/O:		WORK ORDER CHANGES					
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## Process Sheet

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Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 AVE

Job Number: 36962A

Part Number: D206642641

30 min

12/05/2008

S.238 14.24

#1 322.7 F

#2 D206642641 F

#3 B36962A F

#4 B36962A F

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

AVR Aluminum Rod *m107877 BE 08/05/07*

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

AVRSS Rod *m107877 NONE BE 08/05/07*

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

PTO

*58-57*

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-05-08*

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*508/05/09 (X)*

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

*PR. 08-05-12*

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*FL 08/05/12 (X)*

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*M, h 08/06/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-04-25	18	C'BORE, AT LOCATION INDICATED ON ATTACHED DWG DOES NOT NEED TO BE PERFORMED PERMANENT CHANGE	PA	08.04.25	2	PA QSI 042 08.04.25	08/04/09

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36962A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate

B33842

m-h

25.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet

M106825

m-h

26.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet

M15918

m-h

27.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch:

M105819

m-h

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3

A/R LPS-3 Batch:

M104251

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291

Sikaflex expire date:

M107804

08/10

m-h 08/05/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B

Job Number: 36962A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP  
Inserts & Nut plate

*u/A*

*008/05/13 (40)*

30.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: *B37810*

*m-h*

31.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: *B31991*

*m-h*

32.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: *B38433*

*m-h*

33.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: *B31993*

*m-h*

34.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
GASKET  
Batch: *B33964*

*m-h*

35.0

D353621

GASKET



*(12)*

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
GASKET

*B37351 m-h 08/05/13*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36962A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B37352

m-h

37.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B37353

m-h

38.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

WEARPAD

Batch:

B37749

m-h

39.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch:

B33881

m-h

40.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total : 66.0000 Each(s)

BOLT

Batch:

M107737

m-h

41.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch

M107394

m-h

42.0

AN960C10L

washer



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number

Description Batch

78 AN960C10L

Washer

M107939

m-h 08/05/13

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 36962A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

D36831

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

batch

B36319

M. H

44.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring

B33949

M. H

45.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt

M104936

M. H

46.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

washer

batch:

M100993

M. H

47.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

B37755

M. H

48.0

MS27039C105

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch

M107008

M. H

08/05/13

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

49.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(IX)

Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

Sikaflex expire date:

M107804  
08/10

6-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat with MEK Degreasser.

A/R LPS Procyon Batch:

M104251

M-L  
08/05/14

50.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/14 (X)

51.0

PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location:

PPP Rev:

PPP 36962A

8/6/18

SV

52.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/06/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

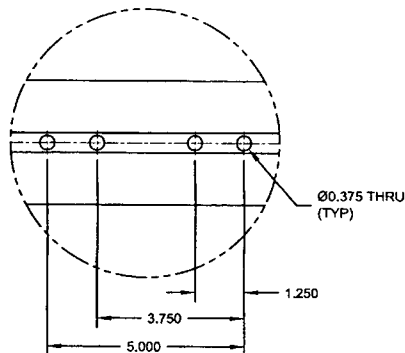
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

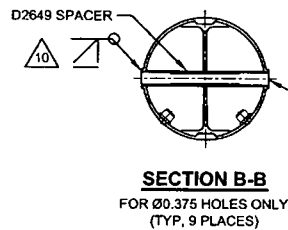
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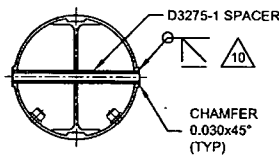




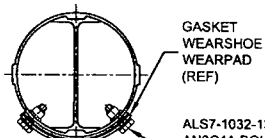
**DETAIL A: DRILL DETAIL**



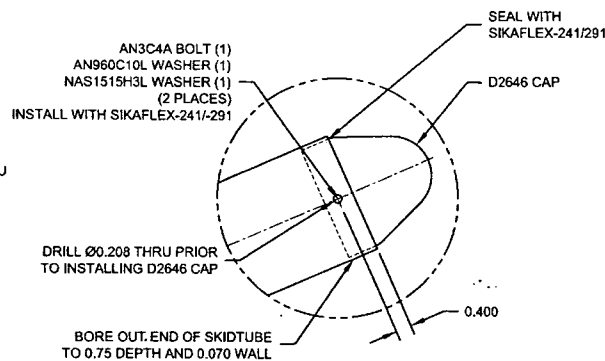
**SECTION B-B**  
FOR 0.375 HOLES ONLY  
(TYP, 9 PLACES)



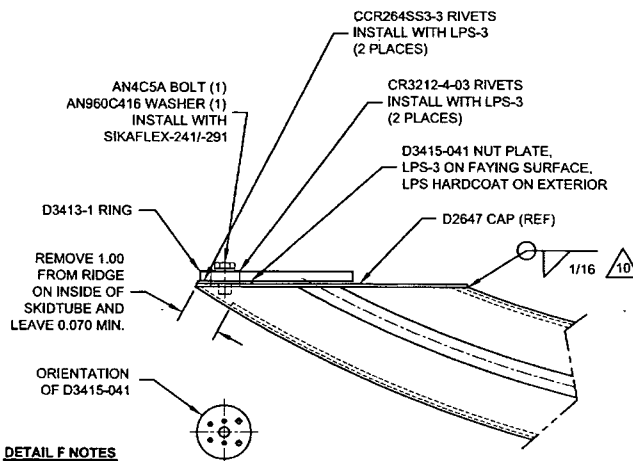
**SECTION C-C**  
FOR 0.313 HOLES ONLY  
(TYP, 6 PLACES)



**SECTION D-D**  
FOR WEARSHOES INSTALL ONLY  
(TYP, 32 PLACES)



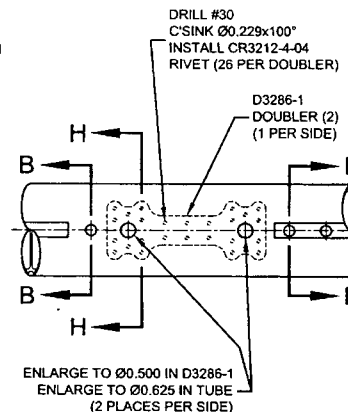
**DETAIL E**



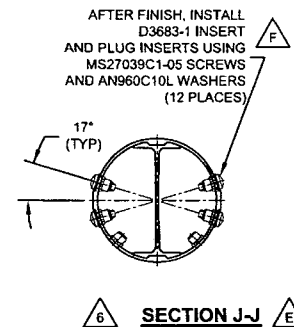
**DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

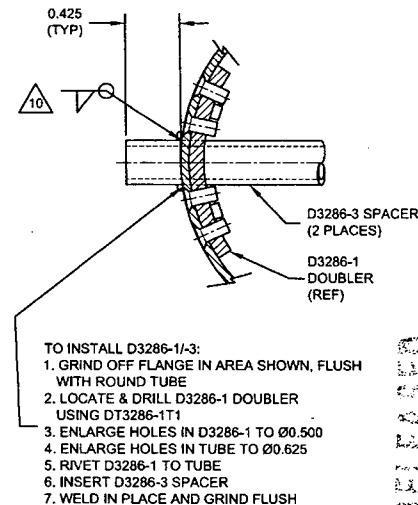
**DETAIL F: END FINISHING DETAIL**



**DETAIL G**  
SCALE 1:5



**SECTION J-J**



**SECTION H-H**  
NOT TO SCALE

DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. F
MFG. APPR.	PC	D3288	SHEET 2 OF 2
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	SKIDTUBE ASSEMBLY	1:3
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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WITHOUT NOTICE  
WORK ORDER  
309624

**Peter Hum**


---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** April 25, 2008 12:33 AM  
**To:** 'Peter Hum'  
**Cc:** 'Chris Provencal'  
**Subject:** RE: D206-642-641 float skidtube and D206-642-141 skidtube

There is no reason to c'bore that hole on -641.  
 OK to sign off a deviation for existing production and update the drawing for the future.

David

---

**From:** Peter Hum [mailto:phum@dartaero.com]  
**Sent:** Thursday, April 24, 2008 9:09 AM  
**To:** David Shepherd  
**Cc:** 'Chris Provencal'  
**Subject:** D206-642-641 float skidtube and D206-642-141 skidtube

David,

Dan Paquette in landing gear noticed an inconsistency between the D206-642-641 float skidtube (D3288-041) and D206-642-141 skidtube (D2650-1):

- a) On D2650-1, the hole immediately forward of the 2 GHW holes that protrude out of the skidtube is NOT C'BORED (see attached)
- b) On D3288-041, the same hole IS C'BORED (see attached)

I did some digging with ChrisP and found out that we have a D206-651 GHW kit that uses the above hole. A D2711 pin goes thru at this location and I think a c'bore would NOT be necessary. Production has been making the D206-642-641 float skidtube WITHOUT the c'bore and it has been shipped to customers.

There is a few D206-642-641 in production, and they are wondering if this hole needs to still be c'bored because that was what they previously have been doing (this problem was only discovered now)

I think we should do the following:

- a) Allow the hole to be NOT C'BORED (i.e. sign a deviation)
- b) Update the drawing to remove the C'BORE

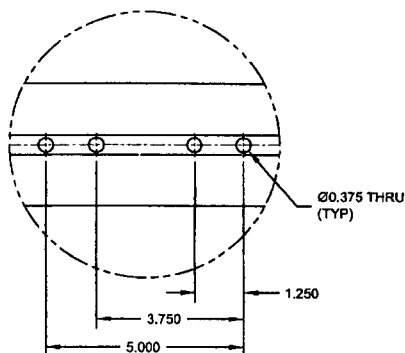
I don't think this will affect anything that has been shipped because the D2711 will still fit and perform as intended.

Is there a specific reason why the float skidtube needs the C'bore but not on the std. skidtube? (I think this detail was missed on the drawing updates of the D3288)

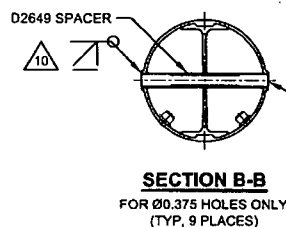
What do you think? Have I missed something?

Peter Hum  
 Mechanical Designer  
 Dart Aerospace Ltd.  
 1270 Aberdeen St.  
 Hawkesbury, ONT, K6A 1K7  
 Tel: (613) 632-5200  
 Fax: (613) 632-9311

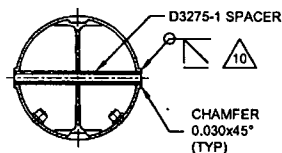
25/04/2008



**DETAIL A: DRILL DETAIL**



**SECTION B-B**  
FOR Ø0.375 HOLES ONLY  
(TYP, 9 PLACES)



**SECTION C-C**  
FOR Ø0.313 HOLES ONLY  
(TYP, 6 PLACES)



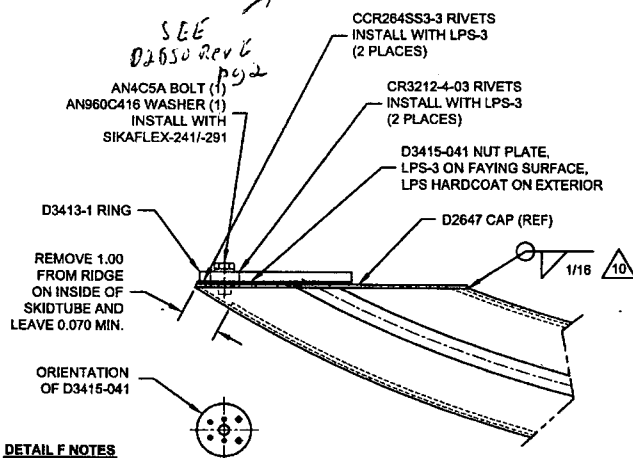
**SECTION D-D**  
FOR WEARSHOES INSTALL ONLY  
(TYP, 32 PLACES)

AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(2 PLACES)  
INSTALL WITH SIKAFLEX-241/-291

DRILL Ø0.208 THRU PRIOR  
TO INSTALLING D2646 CAP

BORE OUT END OF SKIDTUBE  
TO 0.75 DEPTH AND 0.070 WALL

**DETAIL E**



**DETAIL F NOTES**

- CUT TUBE LEVEL
  - REMOVE RIDGE ON FWD SIDE
  - LOCATE D2647 (TRIM AS NECESSARY)
  - WELD D2647 IN PLACE PER DART QSI 004
  - GRIND FLUSH
  - RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

**DETAIL F: END FINISHING DETAIL**

SEAL WITH  
SIKAFLEX-241/291

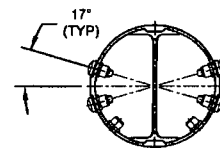
D2646 CAP

DRILL #30  
C'SINK Ø0.229x100"  
INSTALL CR3212-4-04  
RIVET (26 PER DOUBLER)

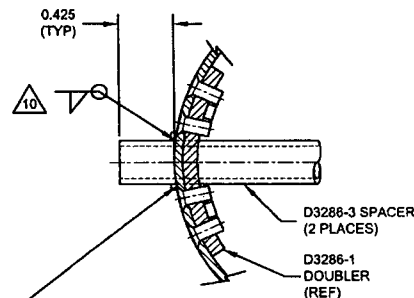
D3286-1  
DOUBLER (2)  
(1 PER SIDE)

ENLARGE TO Ø0.500 IN D3286-1  
ENLARGE TO Ø0.625 IN TUBE  
(2 PLACES PER SIDE)

AFTER FINISH, INSTALL  
D3683-1 INSERT  
AND PLUG INSERTS USING  
MS27039C1-05 SCREWS  
AND AN960C10L WASHERS  
(12 PLACES)



**SECTION J-J**



- TO INSTALL D3286-1/3:
- GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  - LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  - ENLARGE HOLES IN D3286-1 TO Ø0.500
  - ENLARGE HOLES IN TUBE TO Ø0.625
  - RIVET D3286-1 TO TUBE
  - INSERT D3286-3 SPACER
  - WELD IN PLACE AND GRIND FLUSH

**SECTION H-H**  
NOT TO SCALE

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. F
MFG. APPR.	BE	D3288	SHEET 2 OF 2
APPROVED	ME	TITLE	SCALE
DE APPR.	AF	SKIDTUBE ASSEMBLY	1:
DATE	07.11.21	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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SCALE

NO. 155

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 369629  
Part number: D206 612 641  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[ ]

Penetration:

pass[☒] fail[ ]

UNACCEPTABLE

Cracks:

pass[☒] fail[ ]

Undercut:

pass[☒] fail[ ]

Pin holes:

pass[☒] fail[ ]

Overlap (cold lap)

pass[☒] fail[ ]

Porosity (surface):

pass[☒] fail[ ]

Coloration:

pass[☒] fail[ ]

Qualifier Pat Duval Date of Test Coupon 08-05-09

Welder Barclay Elliot Date of Test Coupon 08-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date: Tuesday, 11/03/2008 3:11:52 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : D206-642-641
<b>Job Number</b> : 37829	
<b>Estimate Number</b> : 10804	
<b>P.O. Number</b> :	<b>Part Number</b> : D206642641
<b>This Issue</b> : 11/03/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : RTN FROM HAI
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> :
<b>Previous Run</b> : 00015	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 18/03/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> :	

Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

QC5

INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT PART FROM HAI  
 D206-642-641 B32451A

*AS 03.22*

2.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1  
 PACKAGE PER PPP  
 USING ORIGINAL B/N 32451A

*AS 08/03/25*

3.0

QC21

FINAL INSPECTION/W/O RELEASE



**Comment:** FINAL INSPECTION/W/O RELEASE

*AS 08/03/26*

Job Completion



*u 08-03-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries